

Work Order ID 50758

July 21, 2009 2:30:10 PM

Page 1

Item ID: D2580-1

Accept

Revision ID: D

Item Name: 205 Skidtube bent detail

Start Date: 07/29/2009 Start Qty: 6.00

Required Date: 08/06/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *mf*

Date: *09-07-21* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.

2- Chemical Conversion Coat as per QSI 005 4.1

Seq 101

09/07/21 QC3 inspection

110

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ ☐ Sikaflex-291 ☐ ☐

Sikaflex expire date:

10/01/20

*mill 537
ANM 9-7-29*

6 Ø - ANM 9-7-29

6 Ø BE 9-7-30

6 Ø - ANM 7-7-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 50758

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Page 2

Item ID: D2580-1

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Setup Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 07/29/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 08/06/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC3- Inspect Part Finish

0.00



QC
Quality Control

Memo

0.00

Remove (add at Seq 101)
07/07/29

130

QC5- Inspect part completeness to step on W/O

0.00



QC
Quality Control

Memo

0.00

9-7-30 (6)

140

Identify as per dwg & Stock Location: L.6

0.00



Packaging

Memo

0.00

Packaging

(6) 11 9-7-30

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Page 3

July 21, 2009 2:30:10 PM

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Accept



Setup Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 07/29/2009 Start Qty: 6.00



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Required Date: 08/06/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

0967/31 *[Signature]*

09-7-31 *[Signature]*

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Picklist Print

July 21, 2009 2:30:10 PM

Work Order ID: 50758

Parent Item: D2580-1RevD

Parent Item Name: 205 Skidtube bent detail



Comments:

Start Date: 07/29/2009

Required Date: 08/06/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purely	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/R 	LG - Chris sign-off	Manufactured	No			100	Each	0.0000	6.0000			
Ext'n - 'I' Beam Tube 4"												
D2596RevD 		Manufactured	No			110	Each	4.0000	6.0000			
Web, 205 Skidtube												

B-46468 (6) AWM 9-7-29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

4

50361

4

B-50764

(6) AWM 9-7-30

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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50758
m
09-07-01

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

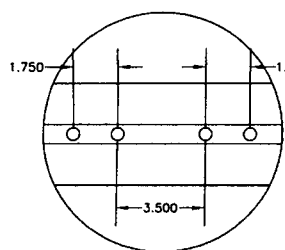
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QA: N/C Closed: _____ Date: _____

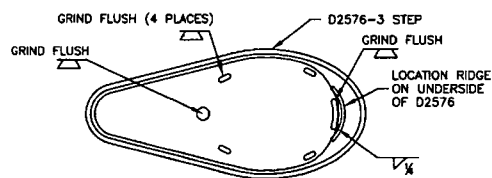
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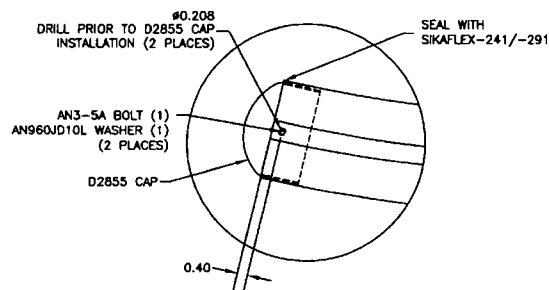
DETAIL A
SCALE 5:24



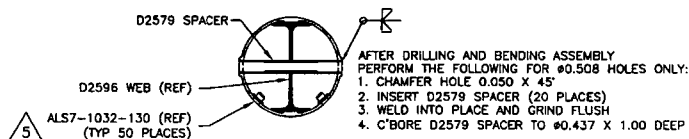
DETAIL B
SCALE 5:24



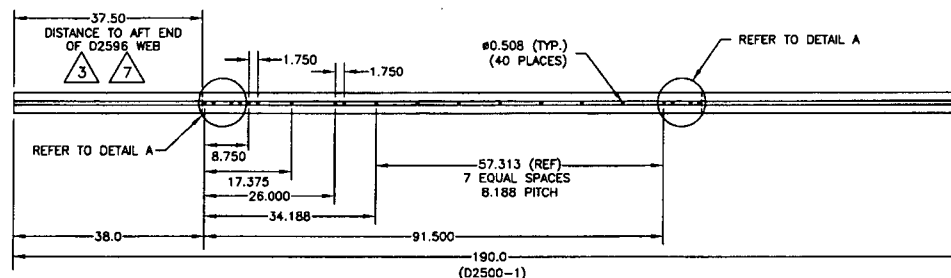
DETAIL C
SCALE 5:24



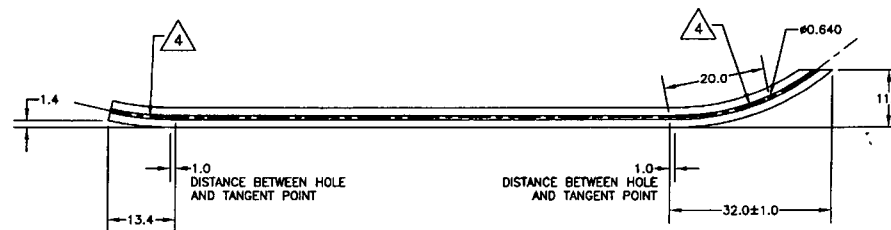
SECTION D-D
SCALE 5:24



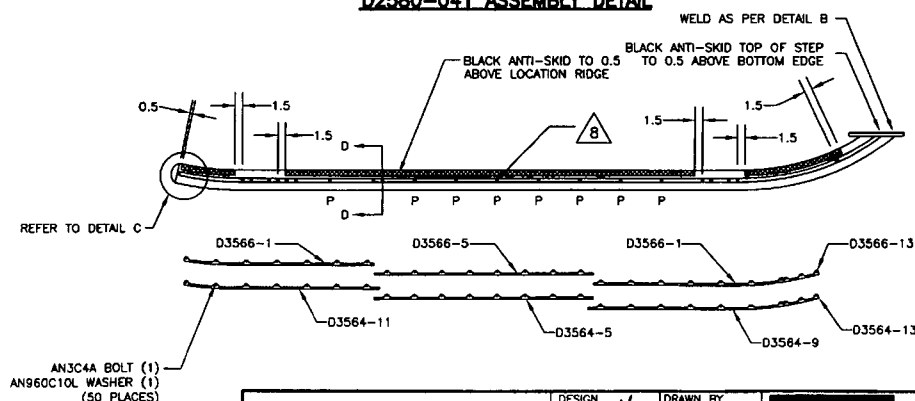
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	07.02.27	D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

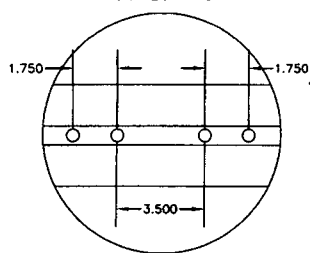
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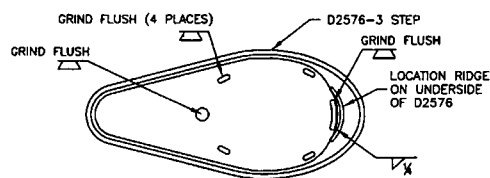
• NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

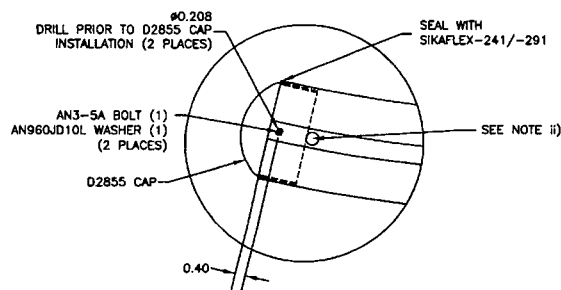


RELEASED
07 Dec 78

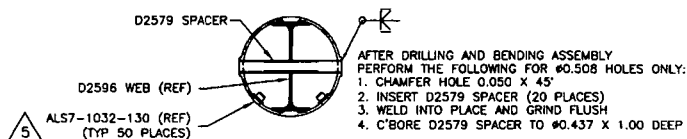
DETAIL F
SCALE 5:24



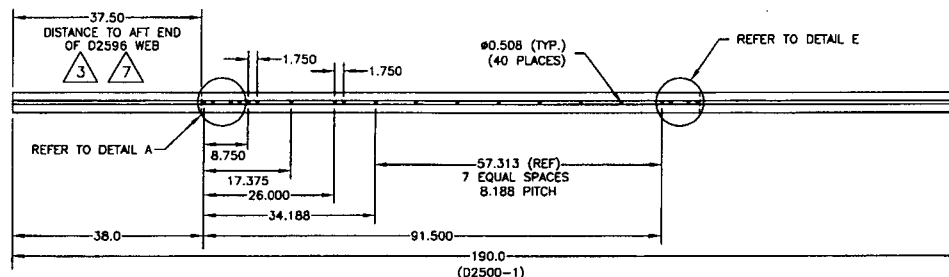
DETAIL G
SCALE 5:24



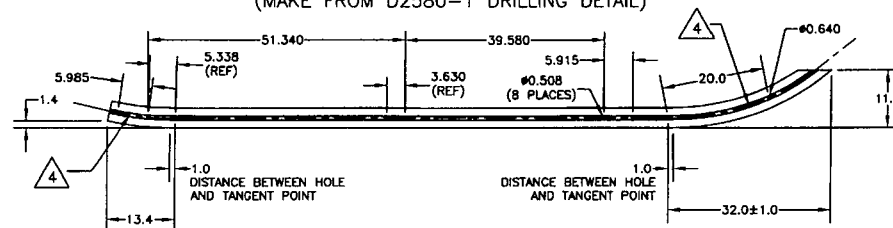
SECTION H-H
SCALE 5:24



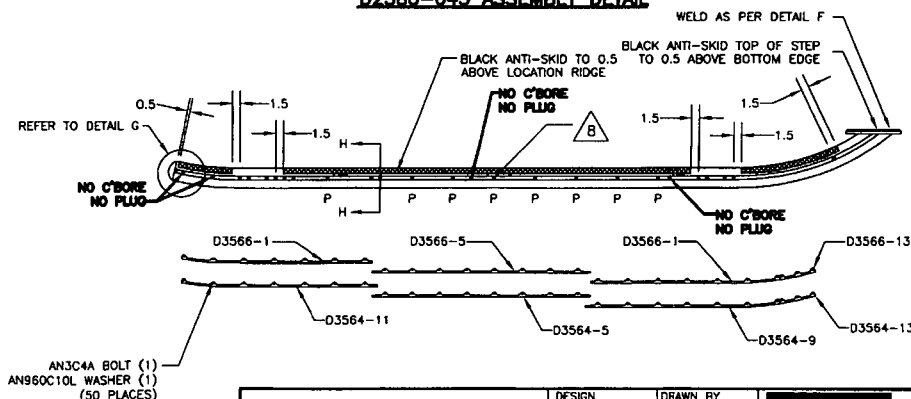
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN P.H.	DRAWN BY R.H.	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. 0 SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

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